

Date: Friday, 23/01/2009 8:46:11 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT PIN BRACKET
Job Number : 45177	
Estimate Number : 11207	
P.O. Number :	Part Number : D333013
This Issue : 23/01/2009 S.O. No. :	Drawing Number : D3330 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 37079	Material :
Written By :	Due Date : 05/02/2009 Qty: 10 Um: Each
Checked & Approved By : <u>DD 09.01.23</u>	
Comment : Est. A 05.01.13 New issue KJ/JLM est b 07.05.14 rev c dwg ec Est C 07.12.12 Rev D dwg EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M1010B2500X01000	1010-1025 Steel Bar 2.50 x 1.00
-----	------------------	---------------------------------



Comment: Qty.: 0.4485 f(s)/Unit Total: 4.4846 f(s)
 1010-1025 Steel Bar
 Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel
 (M1010-B2.500x01.000)
 Identify for D3330-13
 Batch: M107220

ml 09/01/27 (10)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: 2.500" x 1.000" x 3.00" long (+/-0.030)

ml 09/01/27 (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA480 and Dwg D3330
 Identify as D3330-13
 Deburr

ml 09/01/28 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/01/28 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:46:11 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT PIN BRACKET

Job Number: 45177

Part Number: D333013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 09/01/30

(10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Carl*

9/2/2

80

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02

Job Completion



mk 09-0202

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45177
Description: Short Pin Bracket		Part Number: D3330-13
Inspection Dwg: D3330	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

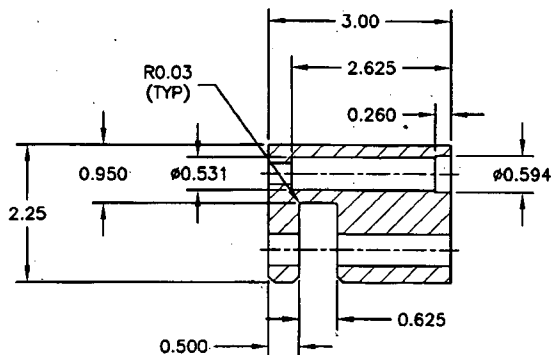
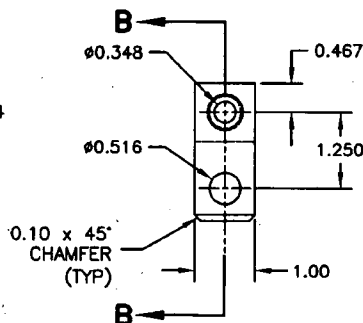
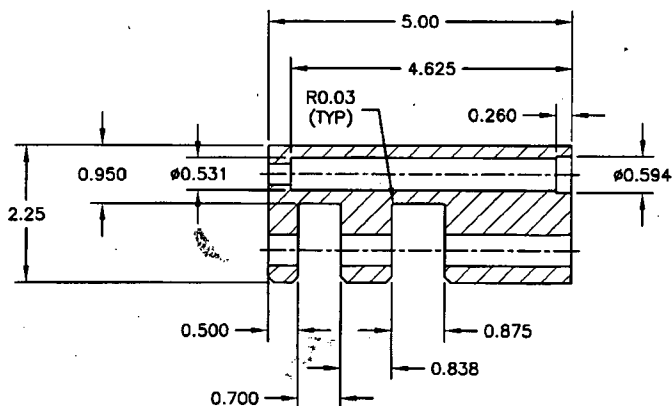
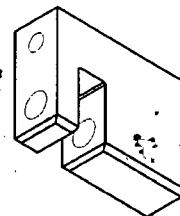
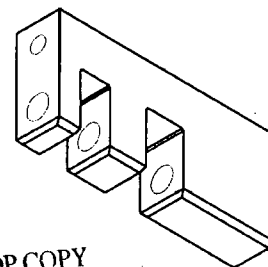
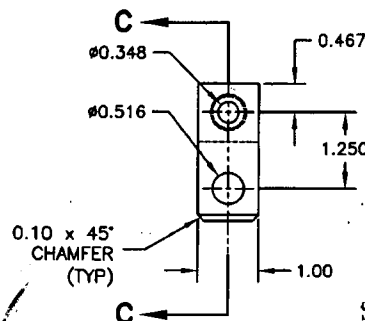
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+/-0.030	3.00	✓			
2.625	+/-0.010	2.626	✓			
0.260	+/-0.010	.256	✓			
Ø0.594	+0.005/-0.001	Ø.593	✓			
0.625	+/-0.010	.621	✓			
0.500	+/-0.010	.500	✓			
2.25	+/-0.030	2.25	✓			
Ø0.531	+0.005/-0.001	Ø.534	✓			
0.950	+/-0.010	.950	✓			
Ø0.348	+0.005/-0.001	Ø.348	✓			
0.467	+/-0.010	.466	✓			
1.250	+/-0.010	1.250	✓			
1.00	+/-0.030	.99	✓			
0.10 x 45°	+/-0.030	.103 x 45°	✓			
Ø0.516	+0.005/-0.001	Ø.519	✓			

Measured by: mmf	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/01/28	Date: 09/01/31	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.16	Dwg Rev updated	KJ/EC	
D	08.04.16	Dwg Rev updated	KJ/DD	[Signature]

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. D SHEET 9 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

**SECTION B-B****D3330-13 SHORT PIN BRACKET****RELEASED**
07.12.07 *[Signature]***SECTION C-C****D3330-11 LONG PIN BRACKET**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4577

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.